

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029032**Date Inspected:** 26-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA observed, at random intervals, ABF/JV welder, Chris Bruce #8901, performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and implementing Caltrans Welding Procedure Specification (WPS) ABF-WPS-D15-1000R-R03. Welding was performed on Tower ESW T, Face B.

RWR-2013-01-036

Y= 8785mm, D=46mm, W=47mm, L=160mm

This QA observed, at random intervals, ABF/JV welder, Eric Sparks #3040, performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and implementing Caltrans Welding Procedure Specification (WPS) ABF-WPS-D15-1000R-R03. Welding was performed on Tower ESW N, Face A.

RWR-2013-01-026

Y= 9140mm, D=45mm, W=42mm, L=130mm

**ESW Excavation**

This QA performed observation of excavation of Electroslag Weld (ESW) designated as ESW F, Face A. Excavation was performed at location (Y= 6870mm~7440mm).

Recorded observations at depth:

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## WELDING INSPECTION REPORT

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-9mm depth

No indications observed

-10mm depth

No indications observed

11mm depth

No indications observed

12mm depth

No indications observed

-13mm depth

No indications observed

Excavation was performed by ABF welding personnel using a mechanical grinder removing approximately 1-3mm at a time. This QA observed Quality Control Inspector William Sherwood performing visual inspection and Magnetic Particle Testing (MT) of this excavation between passes. This QA performed visual inspection and intermittent verification MT of this excavation between passes.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Conversation was relevant to testing performed during this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Clifford, William	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer

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